

**Work Order ID 85299**

Tuesday, June 05, 2012 2:38:57 PM

**\*85299\***

ASAP

Page 1

Item ID: D2809

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bushing

Start Date: 6/5/2012 Start Qty: 40.00

**\*40\***

Cust Item ID:

Required Date: 6/15/2012 Req'd Qty: 40.00

**\*40\***

Customer:

Reference:

Approvals: Process Plan: *UMF*Date: *12-06-05* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2809

Rev A1

100

0.00

**\*100\***

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per Folio FA204

40

0

*12/06/07*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

40

0

*12/06/07*

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*B.A 12/06/07*

40

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85299

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**\*N900040100\***

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**\*40\***

Cust Item ID:

Required Date: 6/15/2012 Req'd Qty: 40.00

**\*40\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

125

Chemical Conversion Coat per QSI005 4.1

0.00

**\*125\***

HandFinish

Memo

0.00

Hand Finishing

40 7/6/12 6.8

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*130\***

Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:20 0.00  
3250 F  
9:50

40X 12/26/08

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

40 12/26/08

M121134

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**Work Order ID 85299****\*85299\***

Page 3

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Accept

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Cust Item ID:

Required Date: 6/15/2012 Req'd Qty: 40.00

**\*40\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

170

Identify as per dwg & Stock Location: 518

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

40

JCE 12/06/08

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/6/11

MF  
12-06-11

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Tuesday, June 05, 2012 2:38:57 PM

Page 1

Work Order ID: 85299

Parent Item: D2809

Parent Item Name: Bushing

Start Date: 6/5/2012

Required Date: 6/15/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP C02.03.07Now turned in houseNG IPP REV:D 11.12.08 added powdercoat per dwg DD  
VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R0.500

Purchased

No

100

f

122.1180

0.0995

4.1894737

6061-T6 Round Bar .500"

4.750'

St 12/06/07

Location

Loc Qty

Loc Code

MAT012

122.118

114488

1.997

117379

9.288

119043

110.833

4.750'

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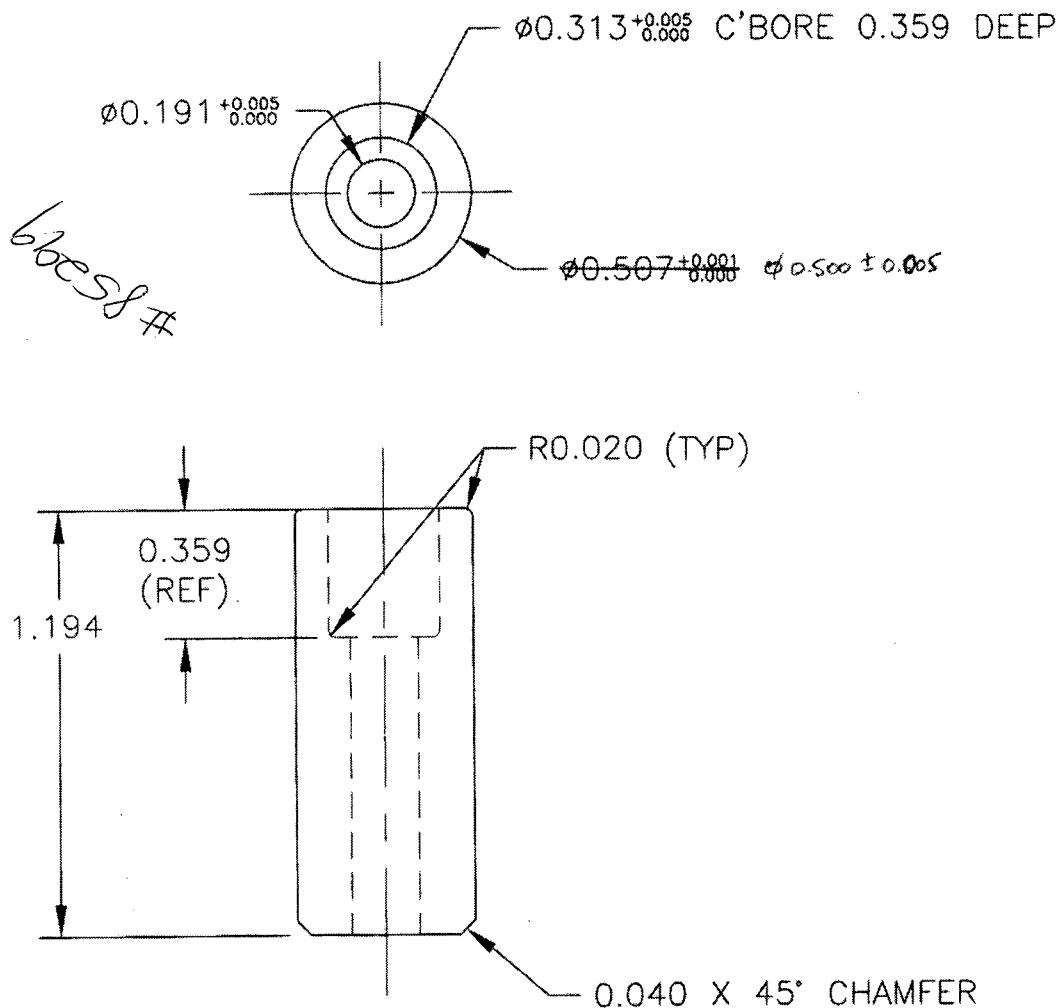
**NOTE:** Date & initial all entries





DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED P	APPROVED #	DRAWING NO. D2809	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	# P 01 04.26	ADD POWDER COAT; $\phi 0.500$ WAS $\phi 0.507$	

RELEASED  
00.11.13 #



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020  
MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8)

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PER DART QSI 005 4.3

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